









Work Order ID 66373


Friday, February 11, 2011 2:01:17 PM


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Item ID:	D2842-042	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Step Assembly RH, 206 Float					
Start Date:	2/14/2011	Start Qty:	3.00	Cust Item ID:		
Required Date:	2/28/2011	Req'd Qty:	3.00	Customer:		
Reference:						

Approvals:	Process Plan:	<u>ME</u>	Date:	<u>11-02-11</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2842	Rev B								
100	Large Fab	0.00							
									
Large Fab	Memo	0.00							
Large Fab	1-Cut D2842-1 using D2622 extrusion as per Dwg D2842								
	2-Drill D2842-1 using Jig DT8272 as per Dwg D2842								
	3-Deburr and bevel ends for welding								
105	QC6- Inspect dimensions to drawing	0.00							
									
QC	Memo	0.00							
Quality Control									
110	Weld per dwg A/R Aluminum rod Batch: <u>M102836</u>	0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1-Weld one end cap and (2) lugs as per Dwg D2842								
	2-Grind end cap weld flush								

11.02.22 3 

11.02.22 3 

11.02.23 3 

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Revision ID:

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Customer:

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

3 0 BE 11/02/28

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

811/02/28

X3
RM

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

11.03.03

3 0

W/O:		WORK ORDER CHANGES					
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Accept

Setup Start

Abstract

Stop

[REDACTED]

[illegible]**Cust Item ID:**[illegible]

Customer:

Reference:

Run Start



Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

[illegible]

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00

[REDACTED]

QC

Memo

0.00

Quality Control

185

0.00

1. The first step is to identify the problem. In this case, the problem is that the company is not meeting its sales targets.

2. The second step is to analyze the problem. This involves identifying the causes of the problem and determining the impact of the problem on the company.

3. The third step is to develop a solution. This involves identifying the actions that need to be taken to address the problem and determining the resources that will be required.

4. The fourth step is to implement the solution. This involves putting the solution into action and monitoring the progress of the implementation.

5. The fifth step is to evaluate the results. This involves assessing the effectiveness of the solution and determining whether the problem has been resolved.

HandFinish

Memo

0.00

Hand Finishing

Touch up step with alodine per qsi 005 prior to powder coat

190

0.00

1. The first step is to identify the key components of the system. This includes understanding the hardware, software, and data involved.

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

RE: 10:00
320
10:30

X3
R

3 BL 11-3-8.

362 11-3-9.

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Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200 	QC3- Inspect Part Finish	0.00				3	0	4103109	
QC. Quality Control	Memo	0.00							
210 	HandFinishing	0.00				3	0	4103109	
HandFinish Hand Finishing	Memo 1-Install inserts as per Dwg D2842 2-Wing Walk as per Dwg D2842 and QSI 005 4.1 Batch: <u>11116-102</u>	0.00							
220 	QC5- Inspect part completeness to step on W/O	0.00							
QC Quality Control	Memo	0.00				73			

Sulorsky

73
RH

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Item Name: Step Assembly RH, 206 Float

Start Date: 2/14/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 2/28/2011 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

230



Packaging

Identify as per dwg & Stock Location: _____

0.00

PP 66319

11/3/14 SL (30)

Memo

0.00

Packaging

240



QC

QC21- Final Inspection - Work Order Release

0.00

11/3/15 JF

Memo

0.00

Quality Control

mf

11-03-14

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Work Order ID: 66373

Parent Item: D2842-042

Parent Item Name: Step Assembly RH, 206 Float

Start Date: 2/14/2011


Required Date: 2/28/2011


Start Qty: 3.00


Required Qty: 3.00

Comments: IPP Rev:D As Per Ecn 766 06-01-06 JLM□□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN960C10L	NAS1149C0332 R	Purchased	No			100	Each	25.0000	3	9			
													
washer													

				Location	Loc Qty	Loc Code							
				ST245	25								
				107534	25								
D2622-120C		Manufactured	No			110	Each	111.6440	1	3			
													
Step Extrusion													

				Location	Loc Qty	Loc Code							
				WA	111.644								
				55214	1.92								
				58544	1								
				61208	4.724								
				64409	104								
D2734		Manufactured	No			110	Each	43.0000	2	6			
													
Step End Plate													

Location	Loc Qty	Loc Code
WA	43	
62931	43	

AN116304

11/03/11

11-02-22

11-03-04

6

W/O:		WORK ORDER CHANGES					
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Work Order ID: 66373

Parent Item: D2842-042


Parent Item Name: Step Assembly RH, 206 Float


Start Date: 2/14/2011

Required Date: 2/28/2011


Start Qty: 3.00


Required Qty: 3.00

D3459-1 Manufactured No 110 Each 41.0000 2 6  11.02.23


 Float Step Mounting Plate


Location	Loc Qty	Loc Code
WA	41	
61213	10	
62955	31	

D3459-3 Manufactured No 210 Each 45.0000 2 6  11.02.23


 Float Step Mounting Plate


Location	Loc Qty	Loc Code
WA	45	
62396	14	
62956	31	

MS27039C1-07 Purchased No 210 Each 43.0000 3 9  11.02.11

 screw

Location	Loc Qty	Loc Code
ST293	43	
111424	3	
115460	40	

NAS1329C3KB130 Purchased No 210 Each 52.0000 3 9  11.02.11

 insert

Location	Loc Qty	Loc Code
ST276	52	
111981	6	
113719	46	

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Shop Packet Print

Page 2

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Parent Item: D2842-042



Parent Item Name: Step Assembly RH, 206 Float

Start Date: 2/14/2011

Required Date: 2/28/2011

Start Qty: 3.00

Required Qty: 3.00

NAS1515H3L

Purchased

No

210

Each

308.0000

3

9



26 110311

WASHER

Location

Loc Qty

Loc Code

FG

40

102472

40

ST277

268

111819

34

113362

234

XG

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

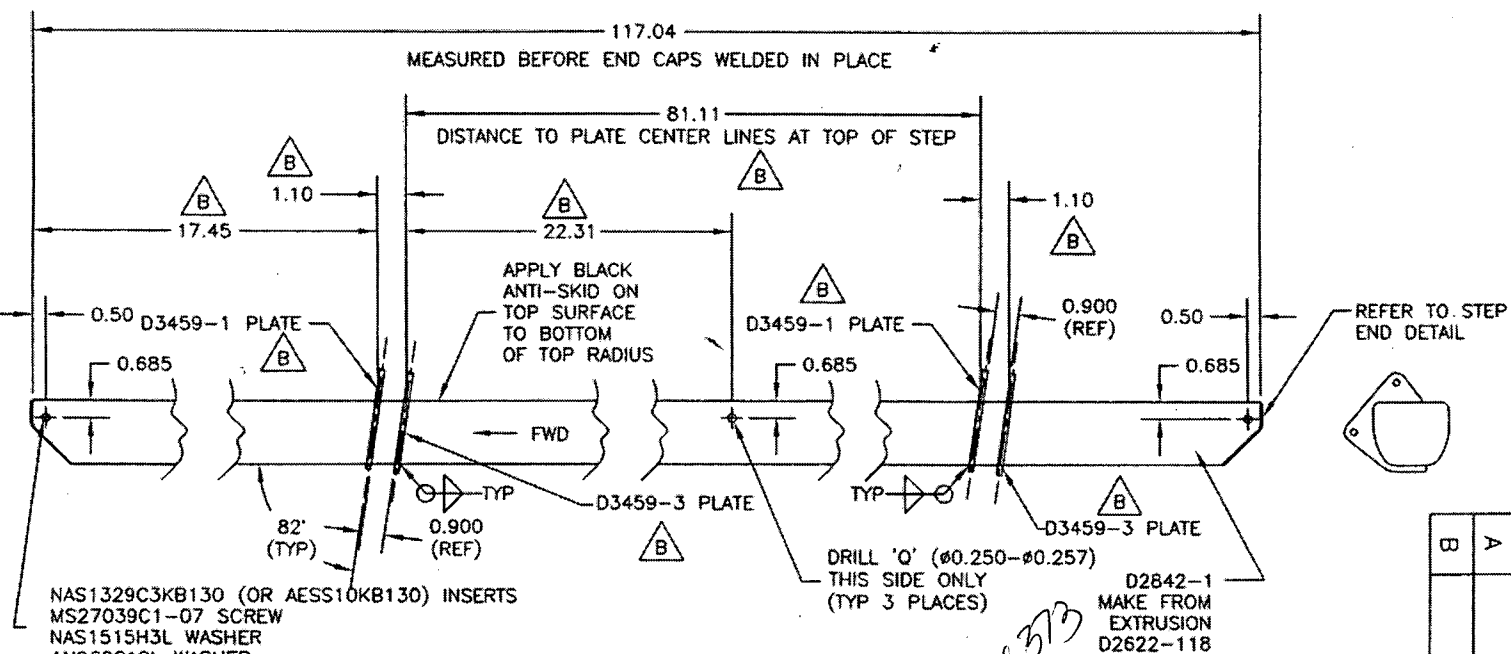
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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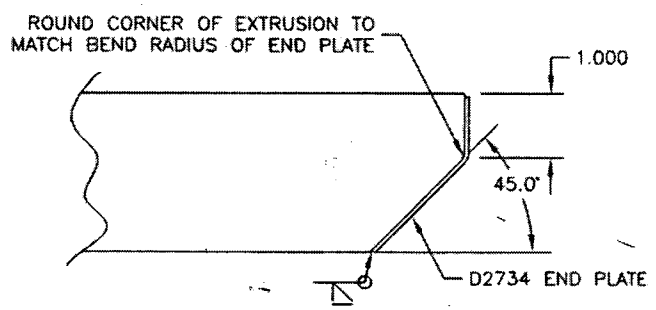
DESIGN	KE	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED		APPROVED		PORT HADLOCK, WA
DATE	05.09.23	TITLE	D2842	REV. B
	A	98.10.13	NEW ISSUE	SHEET 1 OF 1
	B	05.09.23	RE-DESIGN, ADD D3459-1/-3	SCALE
			206L/407 FLOAT STEP ASSEMBLY	NIS



D2842-041 LH STEP ASSEMBLY (SHOWN)
D2842-042 RH STEP ASSEMBLY (OPPOSITE)

D2842-041/-042 FLOAT STEP ASSEMBLY PARTS LIST

QTY	QTY	PART NUMBER	DESCRIPTION
-041	-042		
X		D2842-041	LH STEP ASSEMBLY
	X	D2842-042	RH STEP ASSEMBLY
1	1	D2622-118	EXTRUSION
2	2	D2734	END PLATE
2	2	D3459-1	PLATE
2	2	D3459-3	PLATE
3	3	NAS1329C3KB130 (OR AESS10KB130)	INSERT
3	3	MS27039C1-07	SCREW
3	3	NAS1515H3L	WASHER
3	3	AN960C10L	WASHER



TYPICAL STEP END DETAIL
NOT TO SCALE

D2842-041/-042 FLOAT STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
5.4.14

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